

Work Order ID 81520

March-15-12 8:43:31 AM

81520

Page 1

Item ID: D350-748-201

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Installation, High Aft

Stop ***NS2***

Start Date: 15/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/15 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D350-748-241

F

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPPP350-748-201 CHG002

110

110

CNC Bend 2

CNC Alpha 160 Bender

BENDING MACHINE - CROSSTUBES

Memo

Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT

120

120

QC

Quality Control

QC15- Crosstube Dimensional Check

Memo

SCRAP

Scrap

W/O: 81520		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 350-748-201 PAR #: _____ Fault Category: X - tube NCR: Yes No DQA: AK Date: 12/05/04
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: AK Date: 12/5/7

NCR: 12-1399		WORK ORDER NON-CONFORMANCE (NCR) 2884.53						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-04-23	110	Tube buckled during bending	W 12-05-02	SCRAP GP 12-04-23	KM 12-5-2	TW 12-05-02	W 12-05-02	S 12-05-02

NOTE: Date & initial all entries

Work Order ID 81520***81520***

Page 2

Item ID: D350-748-201

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Installation, High Aft

Start Date: 15/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

125

0.00

125

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Stress relief

Heat treat crosstube as per QSI010 4.3

Temp: _____

Start time: _____

Finish time: _____

127

QC5- Inspect part completeness to step on W/O

0.00

127

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 15/03/2012 **Start Qty:** 1.00 ***1***

Required Date: 04/04/2012 **Req'd Qty:** 1.00 *** 1 ***

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

130

130

Crosstubes

Crosstubes

Crosstubes

Memo

1-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,
Set-up drill table as per QSI 010

2-Deburr

3-Engrave Part # and Batch # as per Dwg D350-748-241

4-Remove all marks from tube within limits of D350-748-241

5- Apply a light coat of LPS3 on the interior of tube
Batch:

0.00

0.00

0.00

0.00

140

140

QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop ***NS2***

Stop ***NS2***

Cust Item ID:

Customer:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

150	Outsource process-Cadplate per QSI017 4.1.9.1	0.00
-----	---	------

Outsource process-Cadplate per QSI017 4.1.9.1

0.00

Memo

0.00

Issue P/O: _____
 Stress relief at 375° for 5 hours
 Magnetic Particle Inspect per ASTM E1444
 Cadum Plate per AMS-QQ-P-416B, Class 1, Type 2
 Embrittle relief at 375° for 8 hours, Chromate Treat
 Possible Supplier: Southwest United Industries
 Ensure Certificate of Conformity is attached

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81520***81520***

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March-15-12 8:43:31 AM

Item ID: D350-748-201

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Installation, High Aft

Start Date: 15/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	SprayPaint	0.00							
180									
SprayPaint	Memo	0.00							
Spray Painting	1-Prime inside crosstube as per QSI 005 4.2 2-Paint Outside of Tube as per Dart QSI 005 4.2								
190	QC14- Inspect Spray Paint	0.00							
190									
QC	Memo	0.00							
Quality Control	Then, Wrap in plastic bag to protect from scratches								
200	Crosstubes	0.00							
200									
Crosstubes	Memo	0.00							
Crosstubes	1-Install Ground wire Insert, then insert screw and washer 2-Install Abraison strips as per Dwg D350-748-241 & QSI 035. 3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81520

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N900040100

Setup Start ***NS1***

Stop ***NS2***

*** 1 ***

Cust Item ID:

* 1 *

Customer:

Reference:

Tooling:

Date:

Run Start *NR1*

SPC (Y/N):

Date:

Stop *NR2*

**Insp.
Stamp**

0.00

210

QC

Memo

0.00

Quality Control

220

Pick Kit

0.00

220

Packaging

Memo

0.00

Packaging

230

QC4- 100% Inspect kits for completeness

0.00

230

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 81520***81520***

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March-15-12 8:43:31 AM

Item ID: D350-748-201

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crosstube Installation, High Aft

Start Date: 15/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

240

Packaging

Packaging

Memo

0.00

0.00

Packaging

Identify and pack for shipping as per PPPD350-748-201

Location: _____

PPP Rev: _____

250

250

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

W120502

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81520

81520

Parent Item: D350-748-201

D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 15/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A New Issue 06-07-05 JLM
 IPP Rev: B Update qty of MS21042L5 06-09-12 KJ
 IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD
 IPP Rev:D 08-06-24 revD as per dwg DD verified by:EC
 IPP Rev: E 08.12.11 Step17 was step 21 KJ Verified by:EC IPP Rev:F
 10.08.04 added QSI010 4.3 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-748-241TRN		Manufactured	No	B73373		110	Each	0.0000	1	①	JW	12-4-3	
D350-748-241TRN										**			
Crosstube Turning Detail													
ALS4-1032-225		Purchased	No			200	Each	1,102.000	1	1			
AI S4-1032-225										**			
Insert													

Location	Loc Qty	Loc Code
ST281	1019	
108696	146	
110768	62	
118386	55	
118966	68	
120671	688	
ST282	83	
120410	70	
120451	13	

AN960JD10 NAS1149D0363J Purchased No

200 Each 0.0000 1 1

AN960JD10

**

Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 81520

81520

Parent Item: D350-748-201

D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 15/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2856-400

Manufactured No

200 f

199.5445 1.181 1.243158

D2856-400

Abrasion Strip

Location

Loc Qty

Loc Code

ST409

199.5445

63735

0.6696

68076

0.3149

71164

8.46

79551

190.1

1- cut as per dwg D2856

D3502-1

Manufactured No

200 Each

39.0000 2 2

D3502-1

Support

Location

Loc Qty

Loc Code

ST051

39

73419

19

74873

20

MS21920-20

Purchased No

200 Each

60.0000 2 2

MS21920-20

Clamp (per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

LG050

60

116799

8

120475

2

120676

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 81520

81520

Parent Item: D350-748-201

D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 15/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-10

Purchased

No

200

Each

258.0000

1

1

MS27039-1-10

Screw

Location

Loc Qty

Loc Code

GA

100

120449

100

ST291

158

120120

158

AN4-41A

Purchased

No

220

Each

387.0000

8

8

AN4-41A

Bolt

Location

Loc Qty

Loc Code

ST360

387

115108

3

115705

7

117619

27

118451

50

118838

50

119328

100

120423

150

AN4-6A

Purchased

No

220

Each

1,649.000

16

16

AN4-6A

Bolt

Location

Loc Qty

Loc Code

ST356

1649

119017

1649

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 81520

Parent Item: D350-748-201

Parent Item Name: Crosstube Installation, High Aft

81520

D350-748-201

Start Date: 15/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-32A	Purchased	No	220	Each	256.0000	4	4
---------	-----------	----	-----	------	----------	---	---

AN5-32A

Bolt

Location

Loc Qty

Loc Code

ST339

256

119328

100

119862

50

120423

75

120717

1

120910

30

AN960JD416	NAS1149D0463J	Purchased	No	220	Each	14.0000	32	32
------------	---------------	-----------	----	-----	------	---------	----	----

AN960.ID416

Washer

Location

Loc Qty

Loc Code

ST351

14

116289

14

AN960JD516	NAS1149D0563J	Purchased	No	220	Each	0.0000	8	8
------------	---------------	-----------	----	-----	------	--------	---	---

AN960.ID516

Washer

D3500-1		Manufactured	No	220	Each	35.0000	4	4
---------	--	--------------	----	-----	------	---------	---	---

D3500-1

Saddle

Location

Loc Qty

Loc Code

ST424

35

73406

8

76000

27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 81520

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Parent Item: D350-748-201

D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 15/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3501-1 Manufactured No

220

Each

361.0000

16

16

D3501-1

Bushing

Location

Loc Qty

Loc Code

ST051

361

67757

4

70682

83

73391

6

74866

207

77033

61

MS21042L4

Purchased No

220

Each

5,585.000

24

24

MS21042L 4

Nut

Location

Loc Qty

Loc Code

ST300

5585

117441

51

117601

157

117885

16

118451

133

119017

232

119075

2996

121011

2000

MS21042L5

Purchased No

220

Each

1,602.000

4

4

MS21042L 5

Nut

Location

Loc Qty

Loc Code

ST300

1602

116105

5

116548

43

117611

42

118179

12

119109

1500

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

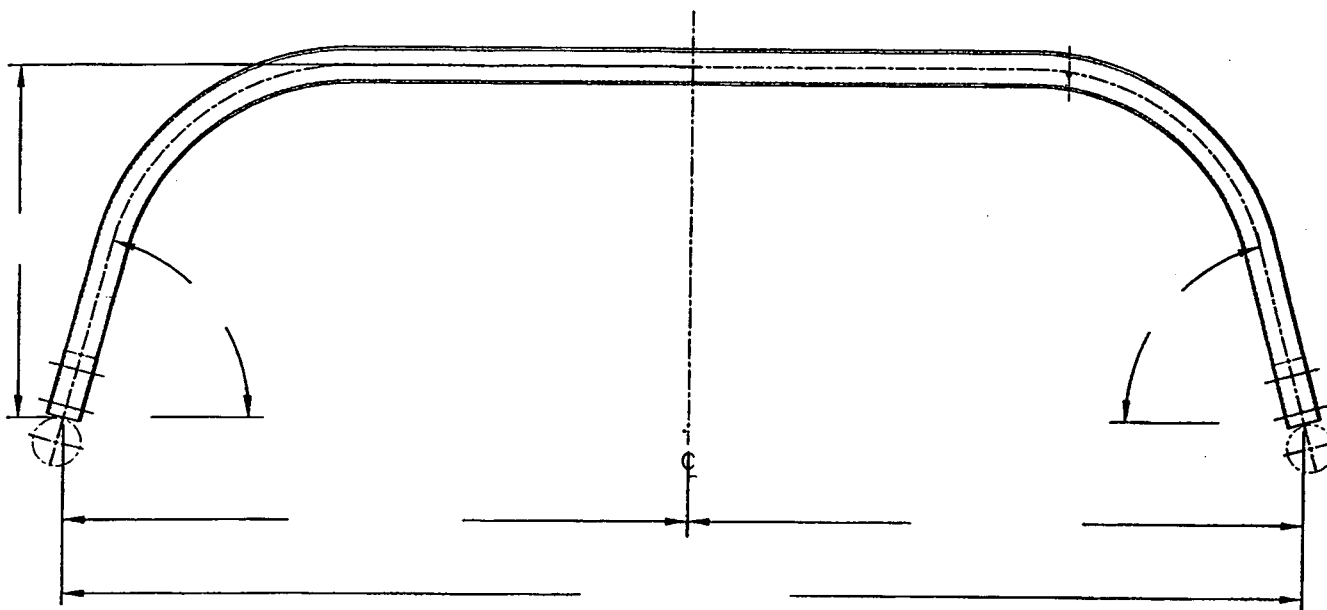
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81520
Description: Crosstube High Aft (AS350/355)		Part Number:	D350-748-201
Inspection Dwg: D350-748-241 Rev: E		Page 1 of 1	

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Item	Qty -241	Part Number	Description
1	X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D6015-125	CROSSTUBE (OR D6018-125)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6018-125
FINISHED LENGTH = 122.700±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-241" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 29.85 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT ALL EDGES FROM MACHINING
LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER
BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO
VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE,
CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,
NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY.
CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE
MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO
CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT
NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 15) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN
CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

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F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A8-3); ADD TOLERANCES (ZN C6-3, D2-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6018-125 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D350-748-241
REV. F
SHEET 1 OF 4
TITLE CROSSTUBE (AS 350/355 HI AFT)
SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

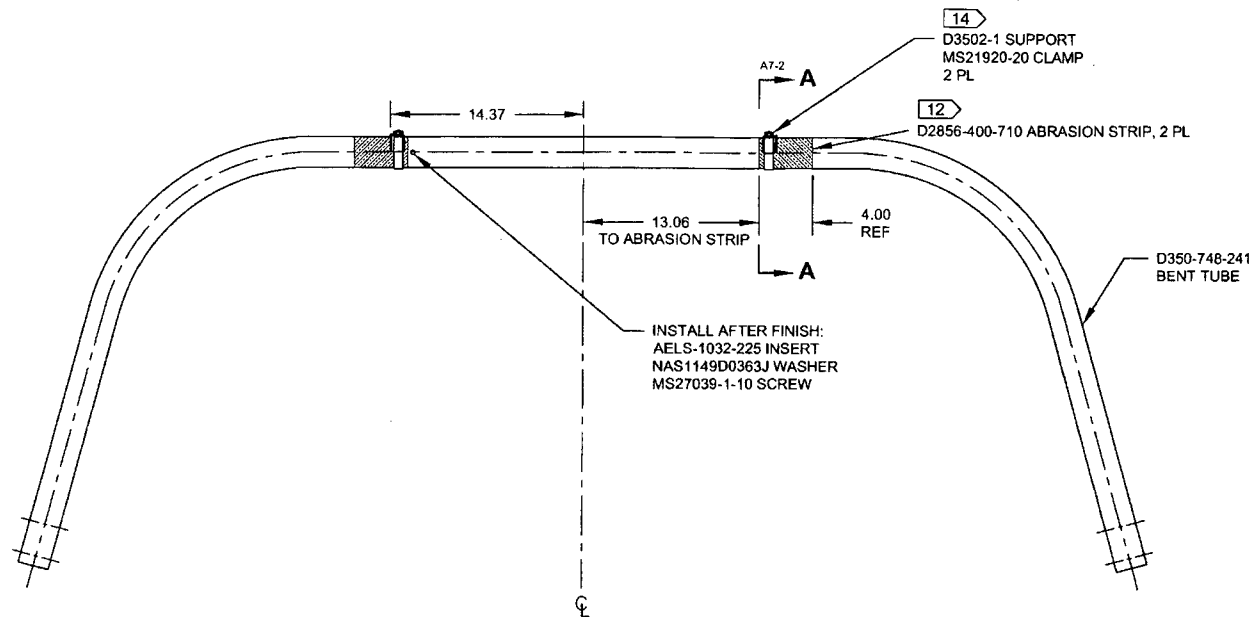
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

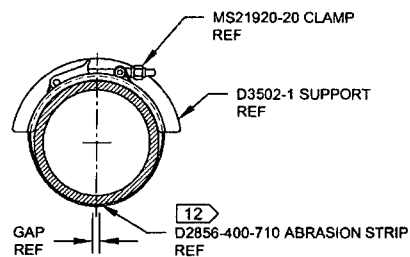
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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**D350-748-241
ASSEMBLY DETAIL**



SECTION A-A D4-2
SCALE 4X

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

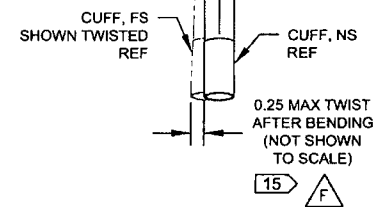
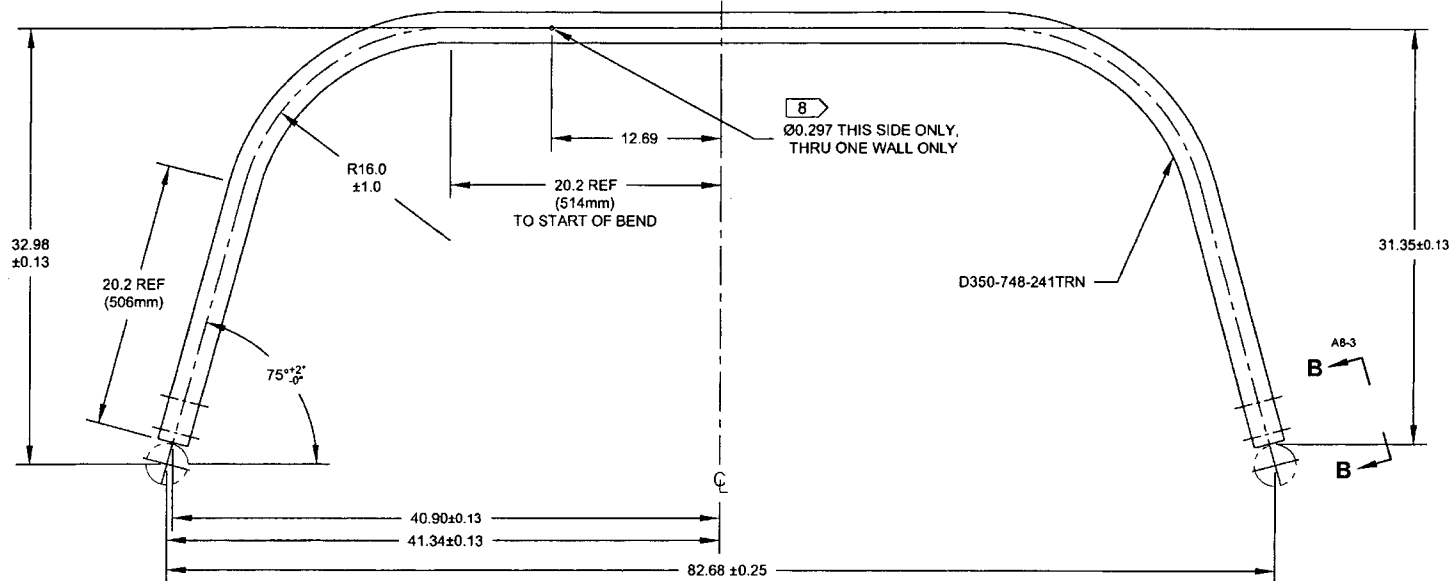
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

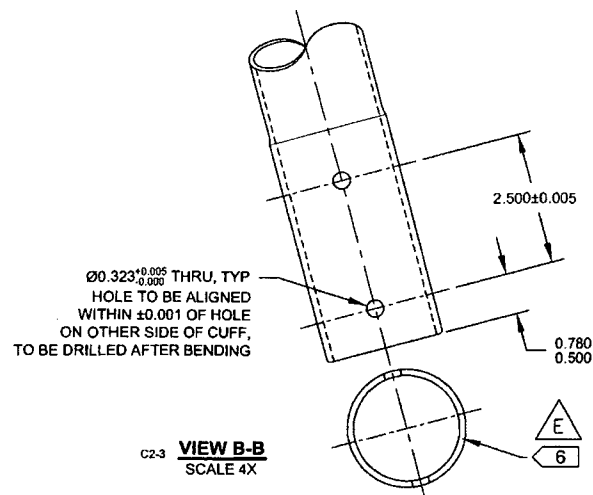
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D350-748-241
BENDING AND DRILLING DETAIL 10

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2011-01-18



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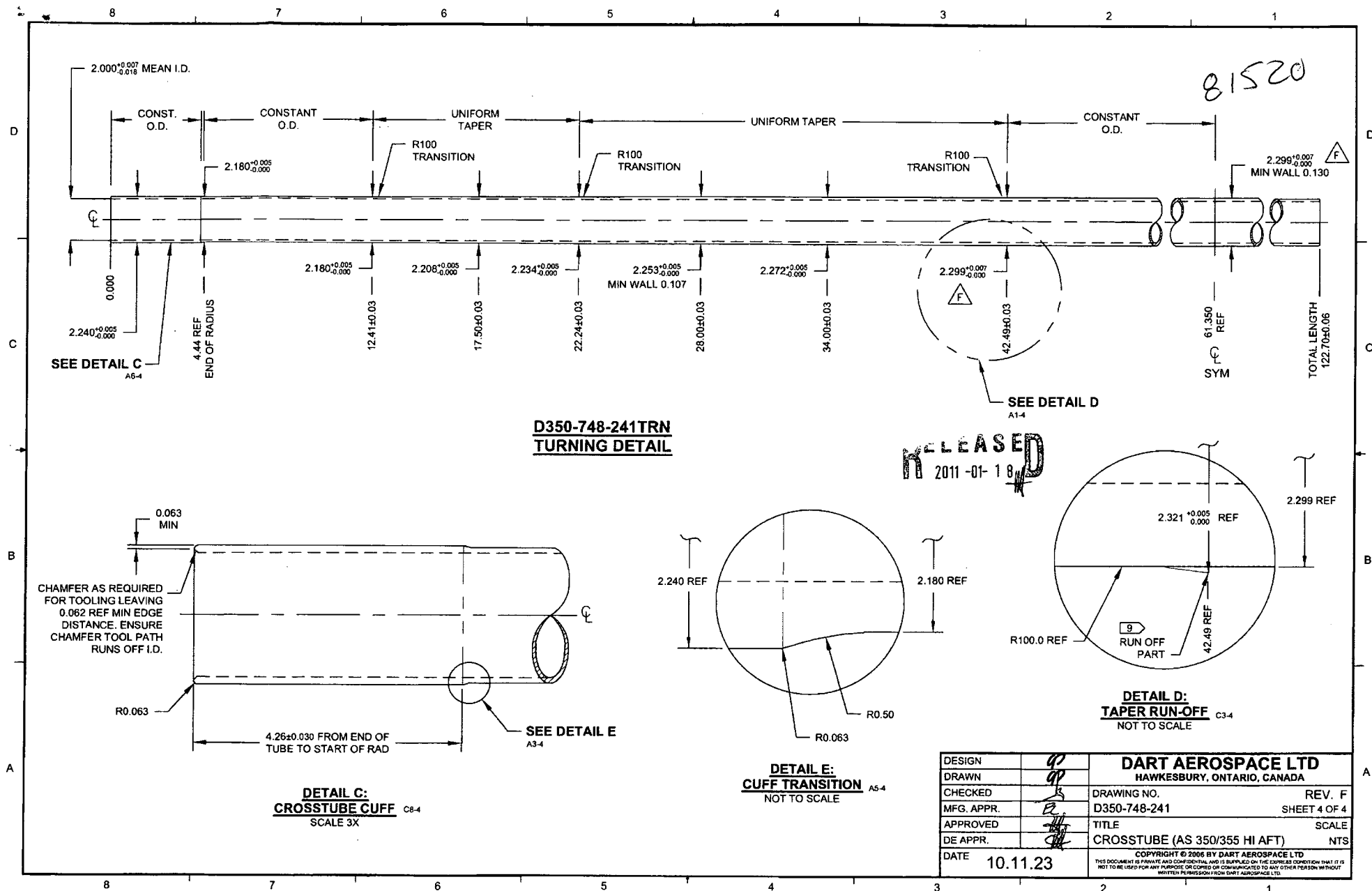
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries